

Work Order ID 119853

May-28-14 7:47:09 AM

119853

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Item ID: D4149-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Lug Plate, Aft

Start Date: 5/28/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/28/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4149	C

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

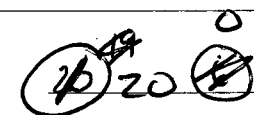
Cut as per dwg D4149

Prog Rev: _____

Dwg Rev: _____

OPEN ~~TO 0.052"~~ HOLES TO FINISH SIZE AS PER DWG

Deburr as required


 DAS
37
9-89 14-05-28

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC:

Quality Control

Memo

0.00


 DAS
37
9-89 14-05-28

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Item ID: D4149-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Lug Plate, Aft
Start Date: 5/28/14 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 5/28/14 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>FT</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

u 14.05.29

Picklist Print

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Work Order ID: 119853

119853

Parent Item: D4149-1

D4149-1

Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 5/28/14

Required Date: 5/28/14

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

157.0000

0.1355

3

M304S11GA

304/316 0.125 Sheet

**

mm 14/05/28

Location

Loc Qty

Loc Code

MAT020

157

122521

30

M128254

127

3

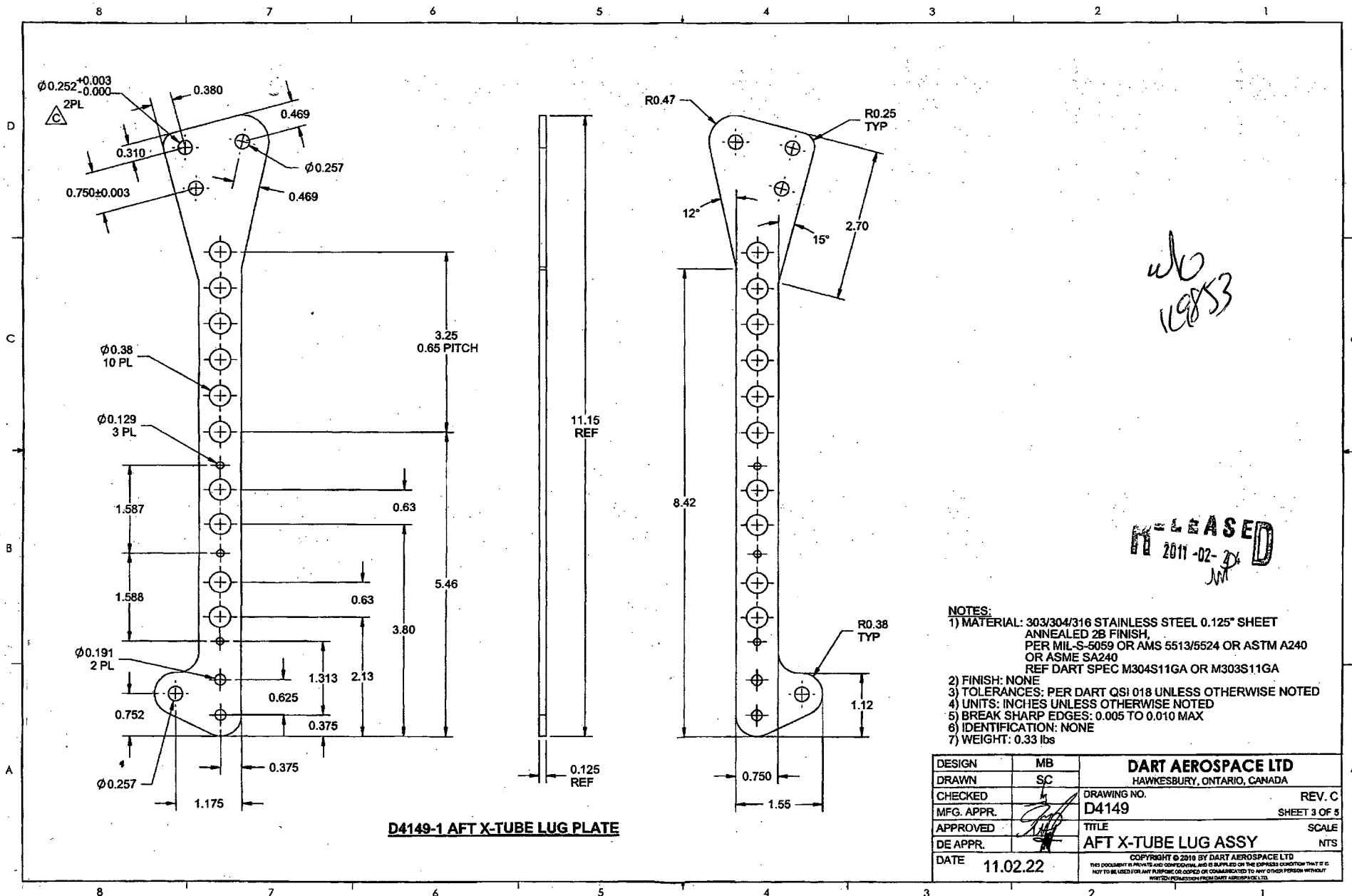
DART AEROSPACE LTD		Work Order: 119853
Description: Aft Crosstube Lug Plate		Part Number: D4149-1
Inspection Dwg: D4149	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST


Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130"	-		✓	Jkms
Ø0.191	+0.005/-0.001	0.193	-		✓	
Ø0.257	+0.006/-0.001	0.259"	-		✓	
Ø0.38	+0.006/-0.001	0.38"	-		✓	
0.380	+/-0.010	0.384"	-		✓	
0.469	+/-0.010	0.475"	-		✓	
0.310	+/-0.010	0.312"	-		✓	
0.750	+/-0.010	0.753"	-		✓	
3.25	+/-0.030	3.256"	-		✓	
0.65	+/-0.030	0.657"	-		✓	
0.63	+/-0.030	0.630"	-		✓	
5.46	+/-0.030	5.46"	-		✓	
3.80	+/-0.030	3.80"	-		✓	
2.13	+/-0.030	2.13"	-		✓	
1.313	+/-0.010	1.313"	-		✓	
0.625	+/-0.010	0.627"	-		✓	
0.375	+/-0.010	0.377"	-		✓	
1.175	+/-0.010	1.175"	-		✓	
0.752	+/-0.010	0.754"	-		✓	
1.588	+/-0.010	1.588"	-		✓	
1.587	+/-0.010	1.587"	-		✓	
11.15	+/-0.030	11.15"	-		✓	Jkms
0.750	+/-0.010	0.750"	-		✓	
1.55	+/-0.030	1.55"	-		✓	
1.12	+/-0.030	1.12"	-		✓	
8.42	+/-0.030	8.42"	-		✓	
2.70	+/-0.030	2.70"	-		✓	
0.125	+/-0.010	0.116"	-		✓	
Ø0.252	+0.003/-0.000	0.254"	-		✓	

Measured by: DAS 37 9-89 Jm	Audited by: DAS 27 9-89	Preliminary Approval:
Date: 14-05-28	Date: 14/5/29	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	



D4149-1 AFT X-TUBE LUG PLATE

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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